

Date: Wednesday, 28/05/2008 1:22:47 PM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 205 SKIDTUBE "I" BEAM
 Job Number : 39538
 Estimate Number : 10346
 P.O. Number :
 This Issue : 28/05/2008 S.O. No. :
 Prsht Rev. : NC Part Number : D2596
 First Issue : / / Type : SKIDTUBES Drawing Number : D2596 REV D
 Previous Run : 39458 Project Number : N/A
 Material :
 Due Date : 06/06/2008 Qty: 5 Um: Each
 Written By :
 Checked & Approved By : JLD 08.5.28
 Comment : Est: D 99.02.02 Changed QA to QC, Added Step 6 and Cost D
 M
 Est Rev:E 07-07-09 Incorporated DEO 9183 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D25003100 Ext'n - 'I' Beam Web 4"



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)
 Extrusion "I" Beam Web 4"

Pick:

X

Qty	Part Number	Description
1	D2500-3-100	Extrusion

Batch

33940 SL 8-5-28

2.0 SKIDTUBES 1 SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

- 1- Cut D2500-3-100 to length: 99.5"
- 2- Use Jig DT8093 to drill pilot holes #30
- 3- Open to 0.630" diameter as per Dwg D2596
- 4- Deburr

7A 8-5-28

3.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid Etch and Alodine per QSI 005 4.1

ANM 8-5-29

4.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08-05-29

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: 205 SKIDTUBE "I" BEAM

Job Number: 39538

Part Number: D2596

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

SKID TUBE CELL

AWM 8-5-29

6.0

QC21

FINAL INSPECTION/W/O RELEASE



08/05/29 JG

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-05-29

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

HAWKESBURY, ONTARIO, CANADA

REV. D

DESIGN	PA	DRAWN BY	OH
CHECKED	11	APPROVED	

CHECK 1

APPROVED

DRAWING NO.

0

06C70

SHEET 1 OF 1

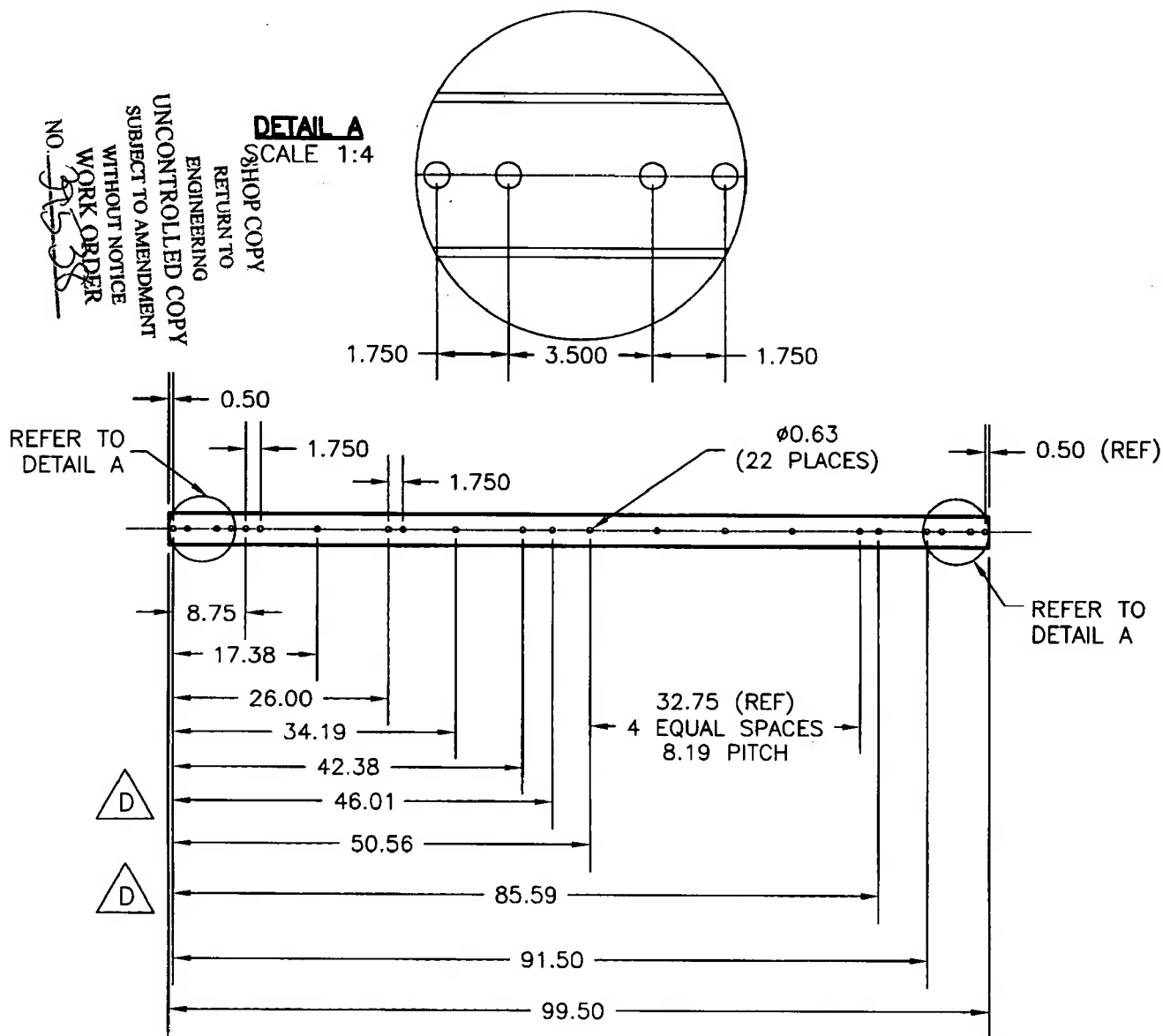
07.04.17

TITLE	
205 WEB	

1:20

RELEASED
07-06-68

A	96.09.16	NEW ISSUE
B	97.07.23	Ø0.63 HOLE WAS Ø0.56
C	98.09.14	INCORPORATED DEO 9097
D	07.04.17	INCORPORATED DEO 9183



DETAIL A
SCALE 1:4

SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 92538

D2596 WEB

- 1) MATERIAL: MAKE FROM D2500-3-100 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) DEBURR SHARP EDGES 0.010 TO 0.020

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